

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004082**Date Inspected:** 01-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:**Magnetic Particle Verification**

This QA inspector received notice of inspection from ZPMC for NDT verification. This QA inspector performed 10% review in Bay 4 for Side plate Green tagging on components SP367-001 and SP099-001 after ZPMC had completed and accepted these components for MT. The QA review found that at the time of the verification weldments appeared to be within compliance. Tower shop Bay 3 deck panel repairs Caltrans received notification for final MT of weldments. This QA inspector performed the 10% review and found that the weldment appeared to be within compliance at the time of review. The review was performed after ZPMC had completed the inspection and accepted the welds for deck panels DP599-001, DP164-001, DP609-001 and DP564-001. These components are now complete for the visual repairs.

OBG UT of Tack welds

This QA inspector documented the "Y" locations of the tack welds were indications were noted from the conventional UT prior to phase array UT for deck panels DP326-001 was recorded for the preliminary UT. Deck Panels DP324-002 was still in process for UT and DP407-001 had been completed but ZPMC had flat plates covering approximately half of the welds to record ZPMC was called and was asked to move these plates, by the end of swing shift these plates were still covering the welds. The documentation was forwarded to the appropriate personnel.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
